



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5069-1

Job Sheet 170776



Part No: D5069-1

Job Qty: 8 ea

Part Name: Hardpoint Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 3/9/18

Type: SOLD

Description:

Note: DWG D5069 REV.A IPP REV:A NEW ISSUE 14-04-06 JLM VERIFIED BY:DD IPP REV:B 18.01.17 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		3/8/18	0.00	0.00	Start Up Machining-3		KA 18-03-20
100	Bandsaw	8 pcs		3/8/18	0.00	0.00	Bandsaw1		KA 18-03-20
110	CNC Vertical Machining	8 pcs		3/9/18	0.00	19.74	HAAS1-4		KA 18-03-20
120	QC	8 pcs		3/9/18	0.00	0.00	QC2 Machining-3		KA 18-03-20
130	QC	8 pcs		3/9/18	0.00	0.00	QC8 Machining-3		KA 18-03-20
135	Outsource	8 pcs		3/9/18	0.00	0.00	Outsource4		CT 18-4-7 AT 18/04/18
140	Packaging	8 pcs		3/9/18	0.00	0.00	Packaging2		AT 18/04/18
160	QC	8 pcs		3/9/18	0.00	0.00	QC6		38
170	Packaging	8 pcs		3/9/18	0.00	0.00	Packaging3-2	ST 11/2	9 DAS 9-08
180	QC21-SA	8 Ea		3/9/18	0.00	0.00	QC21		21

Part Op 100 - Cut blank: 4.200" LONG

Descriptions: 110 - 1- Machine as per Folio FB563 and Dwg D5069 DWG REV: _____ FOLIO REV: _____ Deburr
135 - ISSUE P/O: 039488 TO ATG ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB
CLASS 2
180 - QC21- Final Inspection - Work Order Release

APR 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X04.000	6061T6 Bar 1.500 X 4.00	8 ft (1 ea)	90-Start up Operation	

5042710

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Plex 1/19/18 11:11 AM dart.poulin.mario

Container No: 8053148



Part: D5069-1

Job No: 170776

Serial No/Batch: 8053148

Revision: A

Inspector:

Date: 03/20/18

APR 24 2018

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

DAS
53
9-89Work Order update only ☐

Work Order: <u>170776</u> Part No: <u>1050691</u> NCR No: <u>18-6834</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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<u>0.80 +0.000</u> <u>-0.010 dim is under tolerance</u> <u>by up to 0.003, 0.002</u>		<u>Acceptable.</u> <u>Bearing area at 0.377 hole</u> <u>(0.375 x 0.838 = 0.314 in²) is larger</u> <u>than bearing on 0.787 hole (0.787 x 0.3</u> <u>= 0.236 in²). Part is not critical in</u> <u>region affected by reduced thickness.</u>		Lead hand / Supervisor Approval Verification <u>SA</u> <u>18-03-20</u>																																																																
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DART AEROSPACE LTD		Work Order: 170776
Description:		Part Number: D5069-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/- .030	3.999	✓		Vernier	
2.600	+ .005 / - .000	2.602	✓		Vernier	
2.38	+/- .030	2.374	✓		Vernier	
1.68	+/- .030	1.682	✓		Vernier	
.747 ϕ	+ .002 / - .000	.787 ϕ	✓		Pin gage	
.900	+/- .010	.898	✓		Vernier	
.777 ϕ	+ .002 / - .000	.777 ϕ	✓		Pin gage	
3.75	+ .000 / - .020	3.743	✓		Vernier	
1.20	+/- .030	1.210	✓		high gage	
.310	+/- .010	.313	✓		Vernier	
.130 x 45°	+/- .030	.148 x 45°	✓		Vernier	
.850	+ .000 / - .010	.848	✓		Vernier	
.130 x 45°	+/- .030	.134 x 45°	✓		Vernier	
0.600	+/- .010	.598	✓		high gage	
0.625	+/- .010	.619	✓		high gage	
2.30	+/- .030	2.328	✓		high gage	

Measured by: M.M.	Audited by: [Signature]	Preliminary Approval:
Date: 2018/03/19	Date: 18/03/22	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DQA: _____ Date: _____

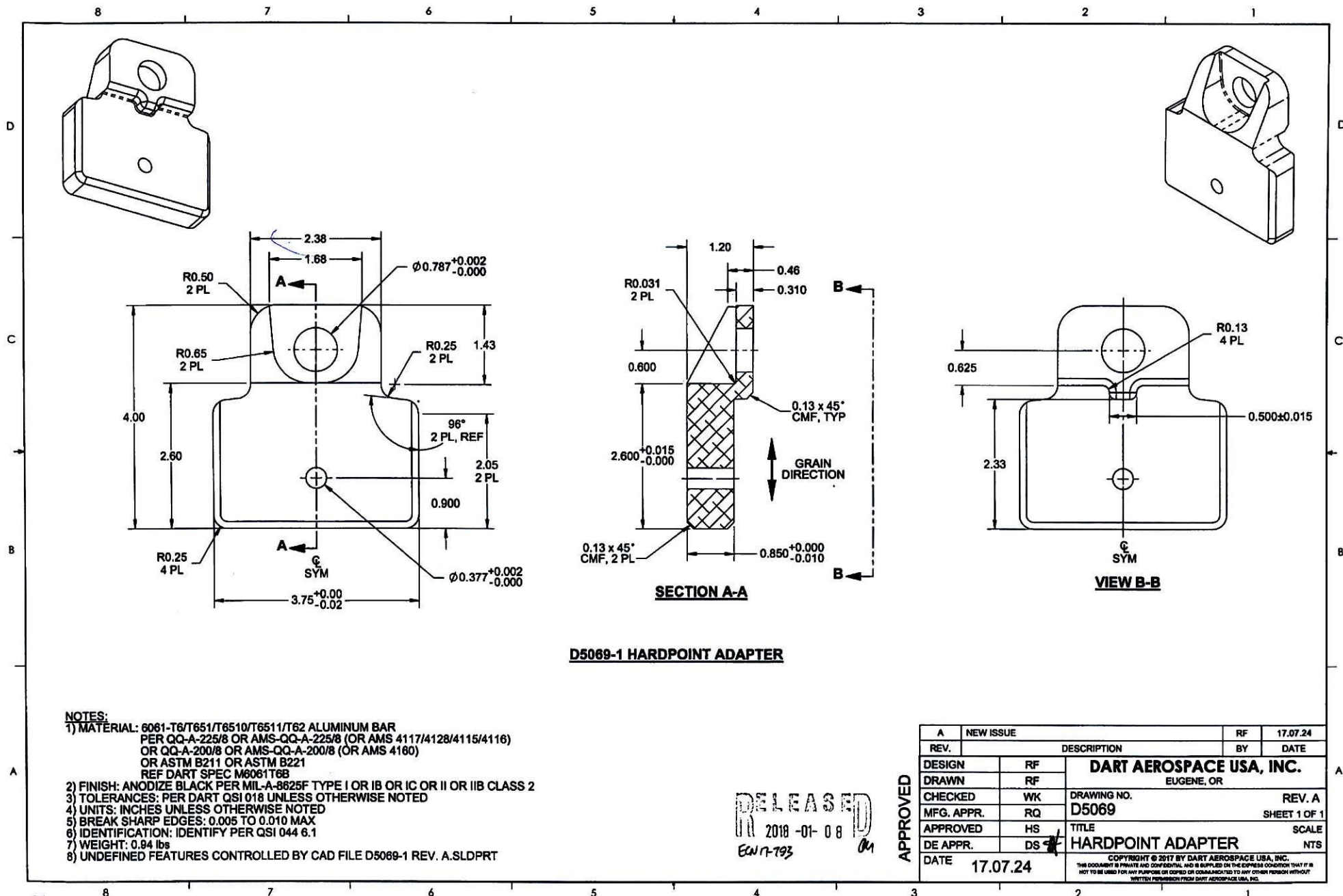


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>176776</u> Part No. <u>D5069-1</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date: <u>2018/03/20</u>	Step #: <u>110</u>	QTY Effective: <u>2</u>	MRB (QSI042) Approval <u>PD 18-3-20</u>						
Description Work Order Deviation <u>0.850^{-0.010}_{+0.000} dim is under 1st part</u> <u>Tolerance by 0.015 on one part.</u> <u>Part Has .100x.100 deep step 2nd part</u> <u>in ø.787 Hole area.</u>		Disposition <u>SCRAP and replace</u> <u>Qty: 2 (S042710).</u>							
		Completed By <u>DAS 1 WT 18-03-20</u> <u>9-89</u> Lead hand / Supervisor Approval Verification <u>LA 18-03-20</u> QC / QA Coordinator Approval <u>PD 18-3-20</u>							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☒ Offset/Setup ☒ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☒ Offset/Setup ☒ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%; vertical-align: top;"> Temperature/Cure ☐ Set-up ☒ BOM/Route ☐ Broken/Damage/Defect ☒ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☒ BOM/Route ☐ Broken/Damage/Defect ☒ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐
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		Positioned Wrong ☐ Outside Dimensions ☐ ☒ Over/Under tolerance Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							



A		NEW ISSUE		RF	17.07.24
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR			
DRAWN	RF				
CHECKED	WK	DRAWING NO.	REV. A		
MFG. APPR.	RQ	D5069	SHEET 1 OF 1		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	HARDPOINT ADAPTER	NTS		
DATE	17.07.24				
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039488**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039488
PO Date: 4/2/18
Due Date: 4/20/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170776	D5069-1	Hardpoint Adapter ISSUE P/O: _____ TO ATG ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2	Firmed	4/11/18	8 pcs	0 pcs	8 pcs	\$11.70/pcs	\$93.60
2	171164	646.3311	RH Half - Upper Cutter Assembly Issue P/O to ATG : _____	Firmed	4/11/18	11 pcs	0 pcs	11 pcs	\$20.85/pcs	\$229.35
3	171056	646.9910	Struts Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	4/11/18	20 pcs	0 pcs	20 pcs	\$16.15/pcs	\$323.00
4	169181	649.5111	LH Wiper Deflector Issue P/O to ATG : _____ AS PER DWG 649.5100 1- Black Anodize as per 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	Firmed	4/11/18	5 pcs	0 pcs	5 pcs	\$19.05/pcs	\$95.25
5	169182	649.5112	RH Wiper Deflector Issue P/O to ATG : _____ AS PER DWG 649.5100 1- Black Anodize 2- PRIME, SEE NOTE #2 Certification of Comformity is required	Firmed	4/11/18	5 pcs	0 pcs	5 pcs	\$19.05/pcs	\$95.25
6	173879	RBE350A94-3701-00	Main Rotor Rigging Tool -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As per Dwg RBE350A94-3701-00 Rev. 2A -Certificate of Comformity is required	Firmed	4/11/18	6 pcs	0 pcs	6 pcs	\$11.70/pcs	\$70.20
Grand Total:										\$906.65

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039488**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039488
PO Date: 4/2/18
Due Date: 4/20/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170776	D5069-1	Hardpoint Adapter ISSUE P/O: _____ TO ATG ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2	Firmed	4/11/18	8 pcs	0 pcs	8 pcs	\$11.70/pcs	\$93.60
2	171164	646.3311	RH Half - Upper Cutter Assembly Issue P/O to ATG : _____	Firmed	4/11/18	11 pcs	0 pcs	11 pcs	\$20.85/pcs	\$229.35
3	171056	646.9910	Struts Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	4/11/18	20 pcs	0 pcs	20 pcs	\$16.15/pcs	\$323.00
4	169181	649.5111	LH Wiper Deflector Issue P/O to ATG : _____ AS PER DWG 649.5100 1- Black Anodize as per 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	Firmed	4/11/18	5 pcs	0 pcs	5 pcs	\$19.05/pcs	\$95.25
5	169182	649.5112	RH Wiper Deflector Issue P/O to ATG : _____ AS PER DWG 649.5100 1- Black Anodize 2- PRIME, SEE NOTE #2 Certification of Comformity is required	Firmed	4/11/18	5 pcs	0 pcs	5 pcs	\$19.05/pcs	\$95.25
6	173879	RBE350A94-3701-00	Main Rotor Rigging Tool -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As per Dwg RBE350A94-3701-00 Rev. 2A -Certificate of Conformity is required	Firmed	4/11/18	6 pcs	0 pcs	6 pcs	\$11.70/pcs	\$70.20
Grand Total:										\$906.65

DAS
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9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914923

Date: 12-Apr-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: D5069-1 Hardpoint Adapter Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils) Job: 22812	Rev: A	PO: PO039488 Line: 1
5 ea	Part: 649.5111 LH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22815	Rev: D	PO: PO039488 Line: 4
5 ea	Part: 649.5112 RH Wiper Deflector Job: 22816	Rev: D	PO: PO039488 Line: 5
6 ea	Part: RBE350A94-3701-00 Main Rotor Rigging Tool Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22817	Rev: 2A	PO: PO039488 Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>12/04/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			



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Terms		Ship Via
		OUR TRUCK
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		